



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6405G04132-3G-6

Job Sheet 192052



Part No: RBW6405G04132-3G-6

Job Qty: 3 pcs

Part Name: Rod



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/15/19

Job Tracking No:

Due Date: 4/12/19

Created By: Marie Lajeunesse

Type: SOLD

Description: order 14090

Note: DWG RBW6405G04132-3G Rev.E IPP Rev. A 19.03.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	SL-154	3 pcs	4/12/19	4/12/19	0.00	0.60	SL-154 - 1		SL 19-4-3
120	QC 8	3 pcs	4/12/19	4/12/19	0.00	0.00	QC 8 - 12		m/19/04/19
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
130	Outsource - 12 - Black Oxide	3 pcs	4/12/19	4/12/19			GRO002-VC		03/05/2019 PL
140	Packaging 2-1 - Receive - B4B	3 pcs	4/12/19	4/12/19	0.00	0.00	Packaging 2 - 1 - B4B		
		2 pcs					Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		

Plex 3/15/19 8:51 AM Dart.lajeunesse.marie



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S169441



Part: RBW6405G04132-3G-6

Job No: 192052

Serial No/Batch: S169441

Revision: E

Inspector:

Exp Date:

Instructions:

Date: 04/03/19

					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	OP APR 15 2019
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
150 QC 6	3 pcs	4/12/19	0.00 0.00		QC 6 - 42	
					QC 6 - 9	DAS
					QC 6 - 68	APR 17 2019 68
					QC 6 - 61	9-89
160 Packaging 3-1 - Stock - B4B	3 pcs	4/12/19	0.00 0.00		Packaging 3 - 1 - B4B	DAS APR 17 2019
					Packaging 3 - 2 - B4B	46
					Packaging 3 - 3 - B4B	9-89
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
170 QC 21 - SA	3 pcs	4/12/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	APR 17 2019 DAS
					QC 21 - SA - 53	70 9-89
Part Op 100 - 1-Machine as per folio FC 713 FOLIO REV: AD DWG REV: E 2-Debur						
Descriptions: 130 - -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Stress Proof -Certificate of Conformity is required						
140 - Certificate of Conformity is required						

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R2.000	AISI 4140 Quenched & Tempered Steel Round Bar 2.000" Dia.	4.3800 ft (1.46 ea)	100-SL-154-1 250-1	5082798 2X 17 3/4

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-SL-154 - 1	MT-4140QT-R2.000	4	4	0

Part Specifications

Specifications could not be found.

Plex 3/15/19 8:51 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:
Description: Rod		Part Number: RBW6405G04132-3G-6
Inspection Dwg: RBW6405G04132-3G	Rev: F	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
-157	±.005	-158	/		VERW	SL-2
-505	±.005	-504	/		9	
15°	±.5°	15°	/		9	
.08	±.01	.08	/		9	
2.166	±.005	2.166	/			
.6238	+0 -.0007	.6237	/		mic	SL-09
2.555	±.005	2.555	/		VERW	
4.054	±.005	4.056	/			
17.315	±.005	17.316	/		VERW	A-1000
.499	±.005	.500	/		UPRN	SL-2
10.31	±.01	10.306	/		UPRN	CNC-02
4.05	±.01	4.055	/			
.23	±.01	.240	/			
R.02	±.01	R.015	/			
.660	±.002	.661	/			
1.772	±.005	1.770	/			
.02x45°	±.01 ±.5°	.015x45°	/			
R.08	±.01	R.08	/			
.375	±.005	.378	/			
1/2-20unf-2A						
major Ø: .4987	+0 -.0081	.497	/			
m.a.w.: .5099	+0 -.0043	.507	/			

Measured by: JL	Checked by: [Signature]	QC Inspector:
Date: 19-4-2	Date: 19/04/04	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

Entered: _____ Date: _____



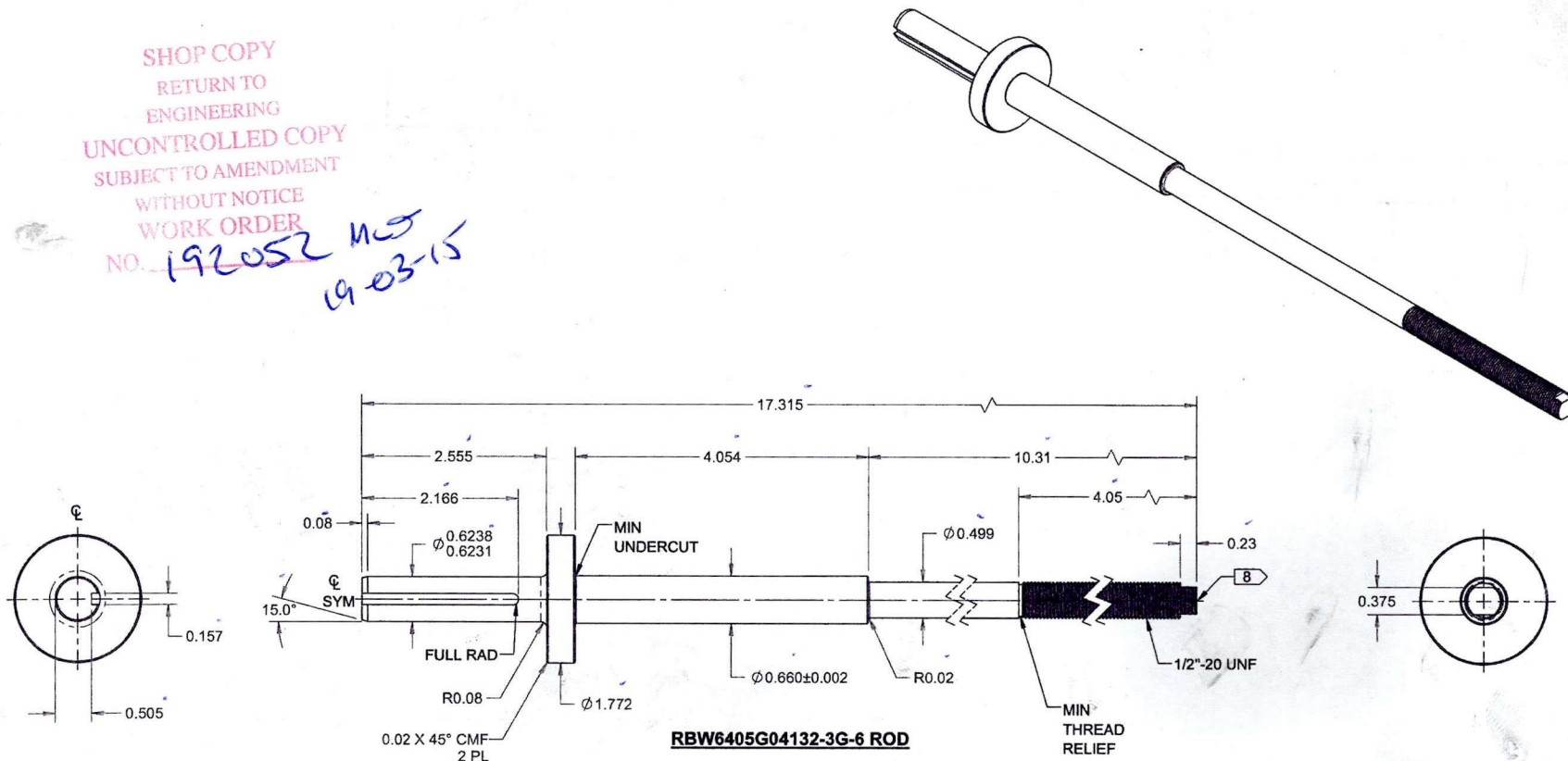
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
11/11/14 11:11		11/11/14 11:11		Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 192052 M-5
19-03-15



RBW6405G04132-3G-6 ROD

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = ± 0.1 " / ± 1 "
X.XX = ± 0.01 " / ± 0.5 "
X.XXX = ± 0.005 " / ± 0.1 "
X.XXXX = ± 0.0005 " / ± 0.05 "
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD		
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA		
CHECKED	VM	TOOL PART #		REV. E
MFG. APPR.	RQ	RBW6405G04132-3G		SHEET 7 OF 9
APPROVED		TITLE	SCALE	
		T/R DUPLEX BEARING INSTALLATION	NTS	
DATE	3/1/2019	COPYRIGHT © 2018 BY DART AEROSPACE LTD		
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043117



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO043117

PO Date: 4/5/19

Due Date: 4/11/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	192052	RBW6405G04132-3G-6	Rod -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Stress Proof -Certificate of Conformity is required	Firmed	-	4/11/19	2 pcs	0 pcs	2 pcs	\$60.00/pcs	\$120.00

Line Item Note *** NEED BACK APRIL 11, 2019 ***

Grand Total: \$120.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043117



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

A handwritten signature in black ink, likely belonging to Patrick Lussier, is written over the bottom right portion of the Order Notes section.

Plex 4/5/19 1:38 PM dart.Lussier.Patrick

**Certificat de Conformité / Certificate of Compliance**
(018276-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip**018276- 1**

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courrier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
10-Apr-2019		Jessie Boisvert			043117			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW6405G04132-3G-6 Rev.	RBW6405G04132-3G-6 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL WIPE OFF EXCESS OIL	OXIDE-BLACK CH	2	2	0	0	0 DAS 68 9-89

Notes Additionnelles / Additional NotesEpaisseur réelle
Actual ThicknessInspecteur Qualité
Quality InspectorRéçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.

E-mail